

Date: Friday, 01/08/2008 10:42:43 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 40899		
Estimate Number	: 11023		
P.O. Number	:	Part Number	: D27493
This Issue	: 01/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2749 REV C
First Issue	: / /	Project Number	: N/A
	Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	:	Material	:
Written By	: <u>JLD 08.08.05</u>	Due Date	: 30/08/2008
Checked & Approved By	: <u>JLD 08.08.05</u>	Qty:	10 Um: Each
Comment	: Est: C 00.05.19 Added inspection level 8, removed P/O for powder coating EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00750	6061-T6 Bar .750 x .750
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Comment: Qty.: 0.7662 f(s)/Unit Total: 4.5971 f(s)

6061-T6 Bar .75" x .75"

Material: 3/4" x 3/4" bar 6061-T6

Batch: M107387

MMF 08/08/07

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank: 8.75" long

MMF 08/08/07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2749-3

SA 08/08/11

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/08/11

(10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:42:43 AM
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Drawing Name: STRUT

Job Number: 40899

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Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

83 08/08/12

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

27/08/08/08/12

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/08/12

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20
32201
10:30

M-1 08/08/13

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-13

100

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 198

8/8/13

50

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/08/14

Job Completion



MF 08-08-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

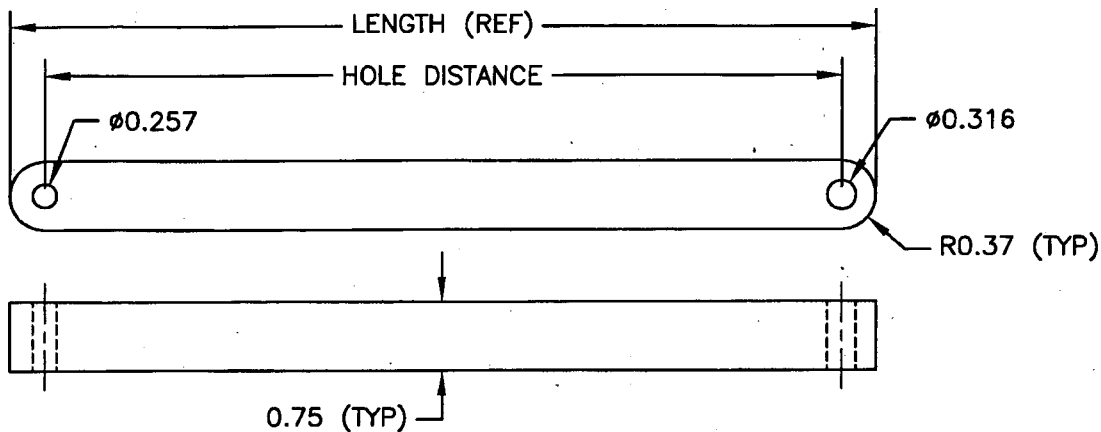
NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2749	REV. C SHEET 1 OF 1
DATE 07.02.13		TITLE STRUT	SCALE NTS
A	99.09.24	NEW ISSUE	
B	99.10.08	REMOVED LIGHTENING HOLES	
C	07.02.13	ADD D2749-9/-11	

RELEASED

07.02.14



DART P/N	HOLE DISTANCE	LENGTH (REF)
D2749-1	8.700	9.45
D2749-3	7.890	8.64
D2749-5	12.630	13.38
D2749-7	10.340	11.09
D2749-9	7.000	7.75
D2749-11	5.188	5.94

D2749-1/-3/-5/-7/-9/-11 STRUT**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR,
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40899

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DART AEROSPACE LTD		Work Order:	40899
Description: <u>STOW</u>		Part Number:	A2749-3
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**[illegible]

Measured by: <u>SD</u>	Audited by: <u>J.L</u>	Prototype Approval:
Date: <u>08/08/11</u>	Date: <u>08/08/11</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	